

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022704**Date Inspected:** 11-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Above**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Bay 4

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on traveler rails. ZPMC CWI Tian Lei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 4 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 3023TR1-002-011

WPS-B-T-2231-ESAB

Welder- 066283

1G/FCAW/CJP

Weld- 3023TR1-003-002

WPS-B-T-2132-ESAB

Welder- 068493

2F/FCAW

Weld- 3009TR1-001-006, 007

WPS-B-T-2132-ESAB

Welder- 068206

2F/FCAW

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Weld- 3007TR2-001-035, 036
WPS-B-T-2132-ESAB
Welder- 037705
2F/FCAW

Bay 7

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on cantilever box beam sub-assembly. ZPMC QC Liu Chuan Gang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Liu Fa Wen as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BK19
WPS-B-P-2112
Welder- 216687
2F/SMAW

Bay 8

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of heat straightening bike path assembly. ZPMC QC Liu Chuan Gang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Liu Fa Wen as the CWI. It was stated that ZPMC had 2 workers performing heat straightening for the following location;

Heat Straightening
HSR1 (B) 10271
BK004A2-062-014, 015, 017, 019, 020

Bay 9

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding and heat straightening on traveler rails. ZPMC QC inspector Duan Ya Bing was present at this time of this observation and informed this QA inspector of the work that is in process and identified Leng Li Gang as the CWI. It was stated that ZPMC had 2 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 3014TR1-002-001
WPS-B-T-2231-ESAB
Welder- 059378
1G/FCAW/CJP

Weld- 3012TR8-001-016
WPS-B-T-2231-ESAB
Welder- 059443
1G/FCAW/CJP

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Heat Straightening
HSRI (B) 10277
3014TR2-001

Heat Straightening
HSRI (B) 10262
3014TR2-002

Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding. ZPMC QC inspector Yu Zhi Lai was present at this time of this observation and informed this QA inspector of the work that is in process and identified Yu Dong Peng as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BK010A8-001-070~078
WPS-B-T-2232-ESAB
Welder- 054069
2G/FCAW/CJP

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike
----------------------	--------------

Quality Assurance Inspector

Reviewed By:	Riley, Ken
---------------------	------------

QA Reviewer
